

Date: Tuesday, 7/18/2006 3:01:14 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 27976		
Estimate Number	: 12450		
P.O. Number	: N/A	Part Number	: D351613
This Issue	: 7/18/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: PRELIMINARY
First Issue	: 7/18/2006	Project Number	: N/A
Previous Run	: 27659	Drawing Revision	: N/A
		Material	: N/A
Written By	: <u>SEA COMMENT (Relay)</u>	Due Date	: 7/25/2006
Checked & Approved By	: <u>06-07-19</u>	Qty:	10 Um: Each
Comment	:		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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Comment: Qty.: 0.0236 sf(s)/Unit Total : 0.2360 sf(s)  
 304/316 .125 Sheet 11GA  
 (M304S11GA)  
 Batch: 1101463

06 07 21

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3516  
 Dwg Rev: A  
 Prog Rev: A  
 2-Deburr if necessary

06 07 21 M.F. 07/24/24 (10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06 07 21 (10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

06 07 24 (10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Form as per Dwg D3516

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-08-04	SO	Parts can not meet bend dimensions. flat pattern is .200 too long.	CP 06-08-04 per QSI/472	Eng. to revise and resize flat pattern. Scrap & destroy	SAD 06-08-04	[Signature] 06-08-04	CP 06-08-04 per QSI/472	[Signature] 06-08-04

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/04

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 7/18/2006 3:01:15 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 27976

Part Number: D351613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

ALL SCRAP.

06/08/09

Job Completion



U 06-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

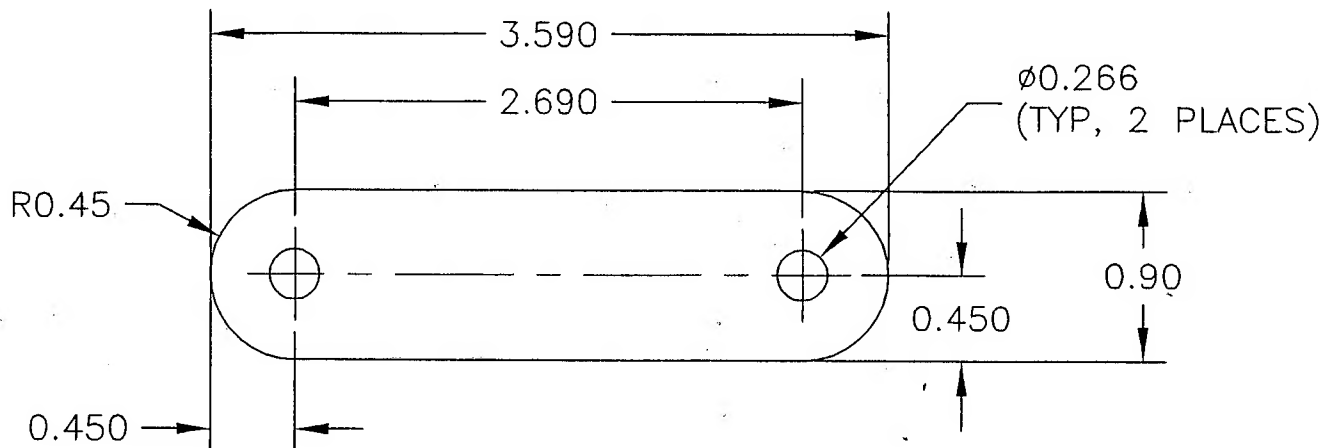
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

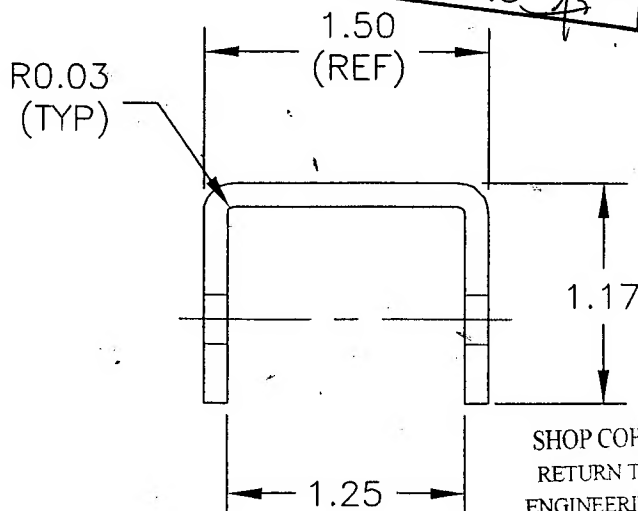
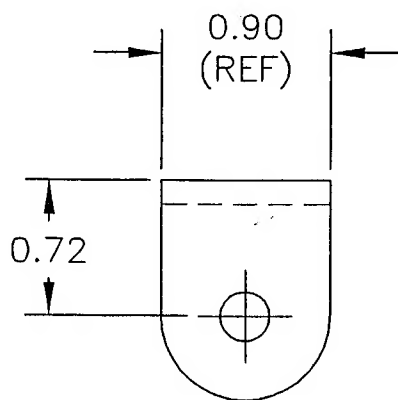
**PRELIMINARY ISSUE**

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3516	REV. A SHEET 5 OF 5
DATE 06.07.14		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1



**D3516-13F CLEVIS FLAT PATTERN**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
(REF. DART SPEC. M304S11GA)



**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
06.07.10 *B*

**D3516-13 CLEVIS BENDING DETAIL**

- 1) MATERIAL: MAKE FROM D3516-13F
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *27976*

